



Empowering you to work smarter

Hand and Drill-Powered
Flaring Tool

NTF67D
User Manual



Failure to follow warnings could
result in death or serious injury.

**SAVE THIS MANUAL
FOR FUTURE REFERENCE**

NAVAC Inc.
www.NavacGlobal.com
Tel/Fax: +1 877 MY-NAVAC
877 696 2822

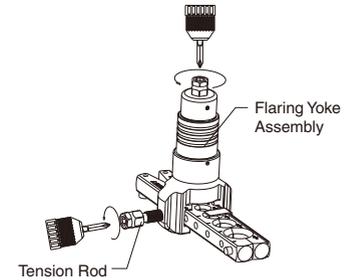
MADE IN CHINA

CONTENTS

PREPARATION	01
OPERATING INSTRUCTIONS (DRILL DRIVEN)	01
OPERATING INSTRUCTIONS (MANUAL)	03
MAINTENANCE	05
APPLICATION	05

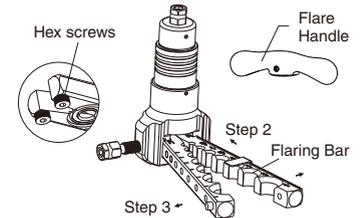
PREPARATION

- Make sure flaring cone is at the upper most position by turning flaring yoke counterclockwise.
- Turn tension rod counterclockwise until it is backed away from the inner chamber of the flaring body.
- Lightly lubricate flaring cone with vacuum pump oil.

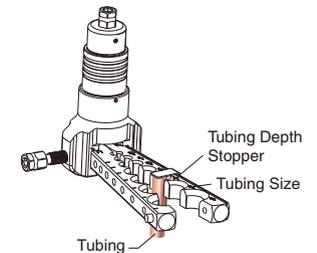


OPERATING INSTRUCTIONS (DRILL DRIVEN)

1. Pull off the flare handle.
2. With the hex screws facing down on the flaring bar, open the flaring bar and insert the flaring bar into the flaring body where the arrow is pointed.
3. Once inserted pull forward and open the flaring bar

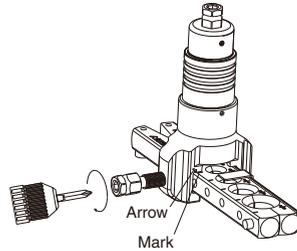


4. Place the tubing depth stopper at the right size. Insert copper tubing up to the tubing depth stopper.

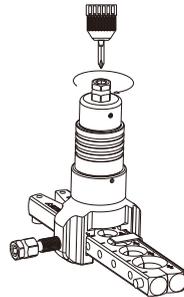


5. Close flaring bar and move the flaring body positioned over the tubing. It should click.

6. Tighten tension rod.



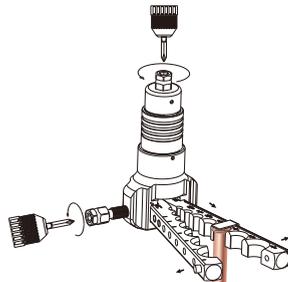
7. Using 1/4" hex drill bit, insert it to the hex socket on the expander end. With the drill set for clockwise turning, start the drill and continue until the clutch engages (clicking).



8. Reverse the direction of the drill to turn counterclockwise and start the drill until the upper position of the flaring cone is reached and the clutch engages (clicking)

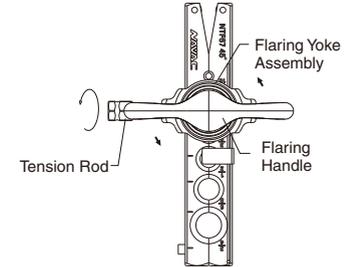
9. Loosen the tension rod.

10. Slide out flaring body towards the end and open flaring bar.



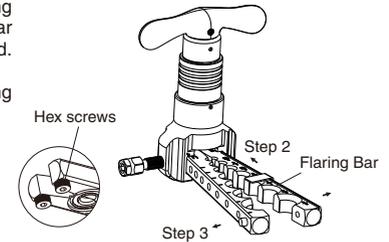
OPERATING INSTRUCTIONS (MANUAL)

1. Make sure the flare handle is properly installed on the flare body.

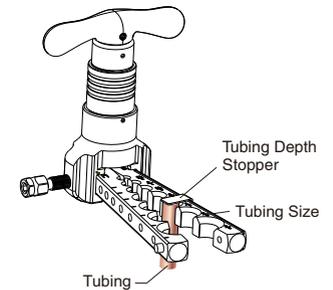


2. With the hex screws facing down on the flaring bar, open the flaring bar and insert the flaring bar into the flaring body where the arrow is pointed.

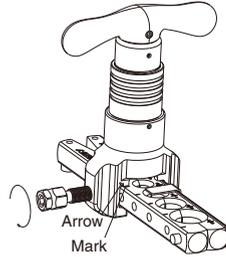
3. Once inserted pull forward and open the flaring bar.



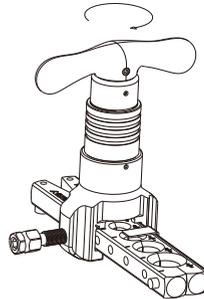
4. Place the tubing depth stopper at the right size. Insert copper tubing up to the tubing depth stopper.



5. Close flaring bar and move the flaring body positioned over the tubing. It should click.
6. Tighten tension rod.



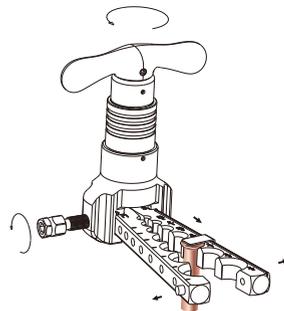
7. Turn the flare handle clockwise and continue until the clutch engages (clicking).



8. Turn the flare handle counterclockwise until the upper position of the flaring cone is reached and the clutch engages (clicking).

9. Loosen the tension rod.

10. Slide out flaring body towards the end and open flaring bar.

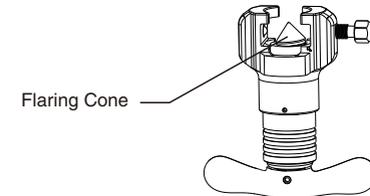


MAINTENANCE

Caution:

Make sure to raise the flare cone before releasing the flare tension rod or you may pinch or cut your hands!

1. Keep the 45° circular cone clean by wiping away any copper dust after using.
2. Add lubricant frequently to the flare block tension rod and flaring drive threads.
3. Frequently grease the inside bearings and coupling of the flaring drive rod.



APPLICATION

Model	NTF67D
Tubing O.D.	3/16", 1/4", 5/16", 3/8", 1/2", 5/8", 3/4"
Accessory	Carry Case, NFG1 Flare Gauge